

Work Order ID 83581

April-19-12 3:53:44 PM

83581

135-692-011

Page 1

Item ID: D3049-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 19/04/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 03/05/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/04/12 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr					(4)			
D3049	Rev A1								

110 0.00
110
 Waterjet Memo 0.00
 FLOW CNC Waterjet CUT BLANK AS PER FILE D3049-1_BLANK
 1812-4-07

120 0.00
120
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 1-Inspect material for defects or damage prior to machining
 2-Machine as per Folio FA165 and Dwg D3049 Identify as D3049-1
 3-Deburr
 SL 12-05-04 (4)

130 0.00
130
 QC Memo 0.00
 Quality Control
 SL 12-05-04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	QC8- Inspect parts - second check	0.00							
140									
QC	Memo	0.00				4	0		
Quality Control									
170	Identify as per dwg & Stock Location: _____	0.00							
170	Packaging								
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

12/05/12 (4)
 12/5/8
 12-05-7

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Picklist Print

April-19-12 3:53:48 PM

Page 1
T

Work Order ID: 83581

83581

Parent Item: D3049-1

D3049-1

Parent Item Name: Bearpaw

Start Date: 19/04/2012

Required Date: 03/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	404.5100	3.4	13.6			

MUHMWB10

UHMW 1" Black

**

12-4-27

Location

Loc Qty

Loc Code

MAT018

83.00999474

120401

0.00999474

120972

3

121346

80

MAT019

1.5

118814

1.5

ST052

320

121277

20

121278

300

121278

4

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DART AEROSPACE LTD		Work Order: 03581
Description: Bearpaw		Part Number: D3049-1
Inspection Dwg: D3049	Rev: A1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	Ø0.260	+0.005/-0.000	260	✓		Vern	2L-10
B	0.93	+/-0.030	925	✓		-	
C	0.40	+0.030/-0.000	414	✓		-	
D	2.00	+/-0.030	2.003	✓		-	
E	10.250	+/-0.010	10.250	✓		Vern	CNC-02
F	4.540	+/-0.030	4.540	✓		Vern	2L-10
G	5.88	+/-0.030	5.878	✓		-	
H	0.38	+/-0.030	376	✓		-	
I	11.50	+/-0.030	11.50	✓			
J	0.07 x 45°	+0.030/-0.010	04X45°	✓		-	
K	0.44 - 0.47	+/-0.000	455	✓		-	
L	R0.25	+/-0.030	25	✓			
M	0.38	+/-0.010	378	✓			
N	0.95	+0.030/-0.010	949	✓			
O	0.69	+/-0.030	690	✓			
P	0.20	+/-0.030	200	✓			
Q	23.00	+/-0.030	23.00	✓		Metape	
R	0.25 x 45°	+/-0.030	26X45°	✓			

Measured by: SL
Date: 12-05-09

Audited by: onk
Date: 12/05/09

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D135-692-011	KJ/RF	
B	08.05.06	Dimension I revised	KJ/DD	

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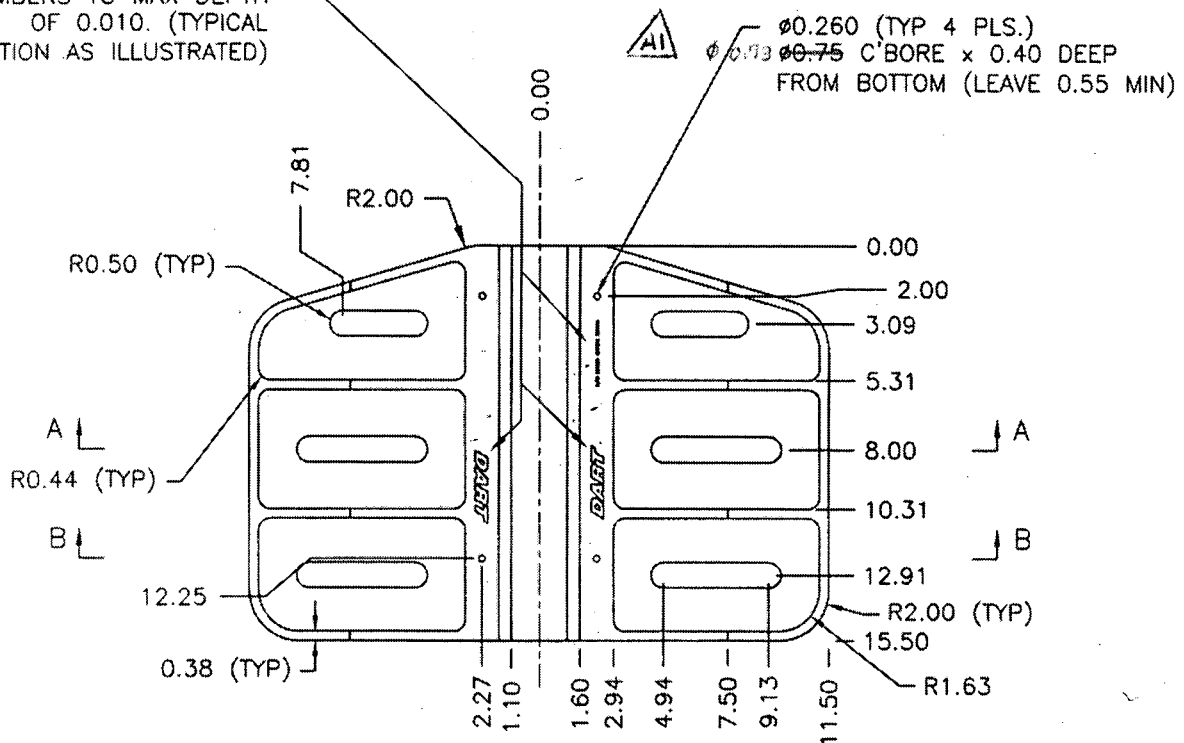
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3049	REV. A SHEET 1 OF 2
DATE 01 10.18		TITLE BEARPAW	SCALE 1:7
A	01.10.18	NEW ISSUE	
AI	03.01.13	φ0.73 was φ0.75	

RELEASED
01.10.24

ENGRAVE DART LOGO TO
MAX DEPTH OF 0.012.
ENGRAVE PART AND BATCH
NUMBERS TO MAX DEPTH
OF 0.010. (TYPICAL
LOCATION AS ILLUSTRATED)



D3049-1 BEARPAW

NOTES:

- 1) BEARPAW IS SYMMETRIC ABOUT CENTER LINE
- 2) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.00" THICK (MACHINE TO 0.950)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 2358 / MCT
12/04/19

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Dart Aerospace Ltd

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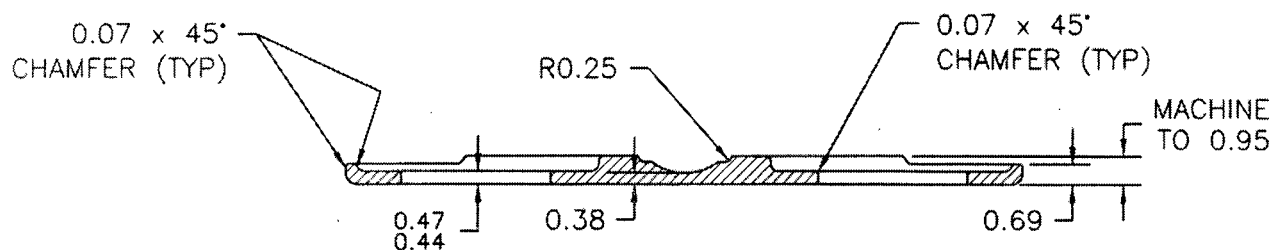
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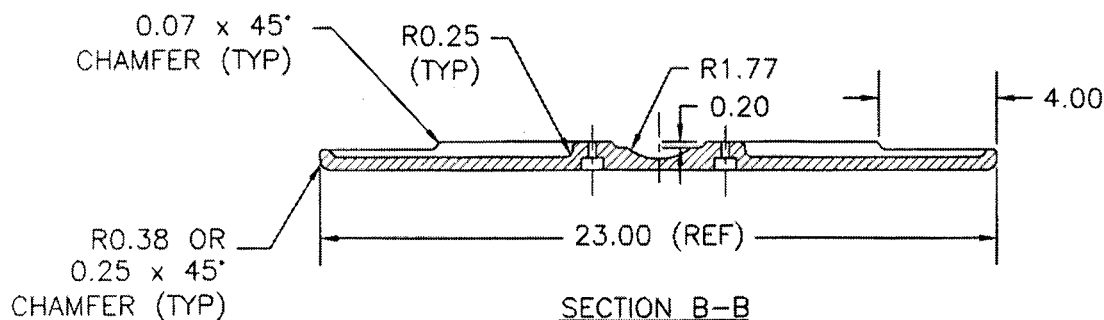


DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3049	REV. A SHEET 2 OF 2
DATE 01.10.18		TITLE BEARPAW	SCALE 1:6

RELEASED
01.10.24 H



SECTION A-A



SECTION B-B

18568

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